

Work Order ID 59520

Friday, June 04, 2010 3:05:50 PM



Page 1

Item ID: D4055-041

Accept



Setup Start



Revision ID:

Item Name: Fuel Tank Assembly

Stop



Start Date: 6/4/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 6/10/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 10-6-07

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4055

A

100

Weld per dwg A/R Aluminum rod Batch: 7112860 0.00

7114242



Large Fab

Large Fab

Memo

0.00

1- weld D4023-1 cap, D3999-11 earth tab and D4008-11 hinge onto D4055-11 as per dwg D4055

2- Weld D4001-1 and D4000-5 onto D4055-1 Top

2- Weld D4055-9 and D4055-11 together

2- weld D3999-041/-043 doubler followed by D3999-9 inside tank, ensure doubler and angle holes line-up for D4000-047

3- Weld D4000-043 and D4000-045 on tank as per dwg.

4- Instal D4000-9 grommets as per dwg, Weld D4055-3 aft end as per dwg, locate D4000-1 fitting using locating jig DTXXXX and weld as per dwg

5-Weld D4055-7 fwd end

10-06-08 *[Signature]*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Reference:

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Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

① PD 10.07.07

10-07-08

121

Weld per dwg A/R Aluminum rod Batch: *M114347* 0.00
M112320

0.00



Large Fab

Memo

0.00

Large Fab

1-Weld top D4055-1

1 of

122

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

① PD 10.07.12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Date:

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Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

123



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

8/10/07/12

Memo

0.00

~~QC~~ Fuel cap in at Qc inspection
8/10/07/12



130



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

1 Bl 10-7-14.

140



QC

Quality Control

QC3- Inspect Part Finish

0.00

8/10/07/12

Memo

0.00

W/O:		WORK ORDER CHANGES					
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Reference:

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Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150



QC

Quality Control

Memo

Pressure test as per dwg

no LEAKS Found. Held Pressure for 8 min to 8:30 AM

0.00

0.00

0.00

0.00

0.00

0.00

160



HandFinish

Hand Finishing

Memo

① PR 10-7-15.

170



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

M112588

Memo

Mask prior to powdercoat

Start Time: 8:55

Oven Temperature: 320°

Finish Time: 9:25

① PR 10-7-23.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

MA 10 07 26 ①

190

0.00



Small Fab

Memo

0.00

Small Fab

Assemble as per dwg

EP 5/10/11/08 ①

200

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Schedule

②

W/O:		WORK ORDER CHANGES					
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Cust Item ID:

Required Date: 6/10/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

0.00



SprayPaint

Memo

0.00

Spray Painting

Seal inside of tank using

sealant

batch: 114133

PR-1005-L -) H 10/09/23

220

0.00



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

S 10/09/09

X + 0

80

230

0.00



Packaging

Identify as per dwg & Stock Location: _____

Memo

0.00

Packaging

PP155498

C 10/11/10 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Cust Item ID:

Required Date: 6/10/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

OK 10/11/16 MF 10-11-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Page 1

Work Order ID: 59520

Parent Item: D4055-041

Parent Item Name: Fuel Tank Assembly

Comments: IPP rev A 10.03.08 new issue prelim EC verified by:DD IPP Rev:B
10.05.17 ECN10-562 DD verf:EC

Start Date: 6/4/2010

Required Date: 6/10/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purchase	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3H5A		Purchased	No				Each	0.0000	5	5			
Bolt													
D4057-1		Manufactured	No				Each	0.0000	3	3			
Retaining Ring													
NAS1149D0363J		Purchased	No				Each	438.0000	5	5			
Washer													

Location

Loc Qty

Loc Code

ST298
113288
114292

438
2
436

0.0000

1

1

D3999-1

Baffle

D3997-5

Placard

Manufactured

No

Manufactured

No

Location

Loc Qty

Loc Code

ST108
55402

10
10

Each

10.0000

1

1

D3997-11

Placard

Manufactured

No

Location

Loc Qty

Loc Code

ST108
55407

10
10

55407

A D3999-1 N/A D3997-1 MF 10-11-8 B 55400

10.06.30 355826 = 3

1

2

55402

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 59520

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Parent Item Name: Fuel Tank Assembly

Comments: IPP rev A 10.03.08 new issue prelim EC verified by:DD
10.05.17 ECN10-562 DD verf:EC

IPP Rev:B

Start Date: 6/4/2010

Required Date: 6/10/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3997-17 Placard		Manufactured	No				Each	10.0000	1	1			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST108				10					
					55410			10		55410			
D3997-29 Placard		Manufactured	No				Each	10.0000	1	1			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST108				10					
					55416			10		55416			
D3997-43 Placard		Manufactured	No				Each	10.0000	1	1			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST108				10					
					55422			10		55422			
D3999-7 Corner		Manufactured	No				Each	7.0000	1	1			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ENG				7					
					55645			7		55645			

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10.05.17 ECN10-562 DD verf:EC

Start Date: 6/4/2010

Required Date: 6/10/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3999-9 Angle		Manufactured	No				Each	5.0000	1	1			
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ENG			5						
					55646		5						
D3999-11 Earth Tab		Manufactured	No				Each	5.0000	1	1			
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ENG			5						
					55863		5						
D3999-041 Baffle Assembly, Aft		Manufactured	No				Each	1.0000	1	1			
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ENG			1						
					55648		1						
D3999-043 Baffle Assembly, Fwd		Manufactured	No				Each	1.0000	1	1			
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ENG			1						
					55649		1						

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Start Date: 6/4/2010

Required Date: 6/10/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4000-1 Fuel Supply Fitting		Manufactured	No				Each	3.0000	1	1		10.06.28	
<div> <div>Location</div> <div>ENG 359698</div> <div>55867</div> </div> <div> <div>Loc Qty</div> <div>3</div> <div>3</div> </div> <div> <div>Loc Code</div> <div></div> </div>													
D4000-5 Fuel Tank Vent Fitting		Manufactured	No				Each	3.0000	1	1		10.07.07	
<div> <div>Location</div> <div>ENG</div> <div>55869</div> </div> <div> <div>Loc Qty</div> <div>3</div> <div>3</div> </div> <div> <div>Loc Code</div> <div></div> </div>													
D4000-9 Grommet		Manufactured	No				Each	0.0000	3	3		10.06.30	359486=2
* D4000-041 041 Drain Fitting Assembly, Fwd		Manufactured	No				Each	0.0000	1	1		10.06.28	58034 359480
D4000-045 043 Fuel Pickup Fitting Assembly		Manufactured	No				Each	0.0000	1	1		10.06.29	359480
D4000-047 045 Fuel Pickup Fitting Assembly		Manufactured	No				Each	0.0000	1	1		10.06.28	359482

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10.05.17 ECN10-562 DD verf:EC

Start Date: 6/4/2010

Required Date: 6/10/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4001-1 Fitting		Manufactured	No				Each	1.0000	1	1		10.07.07	

Location Loc Qty Loc Code
ENG 1

D4008-041 Fuel Filler Splash Guard Assembly		Manufactured	No	56401			Each	0.0000	1	1		59988 C10/11/8	
--	--	--------------	----	-------	--	--	------	--------	---	---	--	----------------	--

D4008-11 Hinge Half		Manufactured	No				Each	0.0000	1	1		10.07.08 359490 (P)	
------------------------	--	--------------	----	--	--	--	------	--------	---	---	--	---------------------	--

D4023-1 Cap and Flange		Manufactured	No				Each	4.0000	1	1			
---------------------------	--	--------------	----	--	--	--	------	--------	---	---	--	--	--

Location Loc Qty Loc Code
ENG 4
55943 4

D4025-1 Fuel Quantity Sender		Manufactured	No				Each	4.0000	1	1		355943 C10/11/8 (1)	
---------------------------------	--	--------------	----	--	--	--	------	--------	---	---	--	---------------------	--

Location Loc Qty Loc Code
ENG 4
55937 4

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Start Date: 6/4/2010

Required Date: 6/10/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4055-11  Tank Front and Bottom		Manufactured	No				Each	2.0000	1	1			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ENG				2					
					<u>55962</u>			2					
D4055-9  Tank Back		Manufactured	No				Each	2.0000	1	1			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ENG				2					
					<u>55961</u>			2					
D4055-7  Tank Fwd End		Manufactured	No				Each	2.0000	1	1			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ENG				2					
					<u>55960</u>			2					
D4055-5  Tank Upper Cut Out		Manufactured	No				Each	2.0000	1	1			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				2					
					<u>55959</u>			2					

Friday, June 04, 2010 3:05:55 PM

Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, June 04, 2010 3:05:55 PM

Page 7

Work Order ID: 59520

Parent Item: D4055-041

Parent Item Name: Fuel Tank Assembly



Comments: IPP rev A 10.03.08 new issue prelim EC verified by:DD IPP Rev:B
10.05.17 ECN10-562 DD verf:EC

Start Date: 6/4/2010



Required Date: 6/10/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4055-3		Manufactured	No				Each	2.0000	1	1			
													
Tank Aft End													

10.06.28

				<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>							
				ENG	2								
					<u>55957</u>								
D4055-1		Manufactured	No				Each	2.0000	1	1			
													
Tank Top													

10.07.08

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ENG	2	
	<u>55963</u>	
	2	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

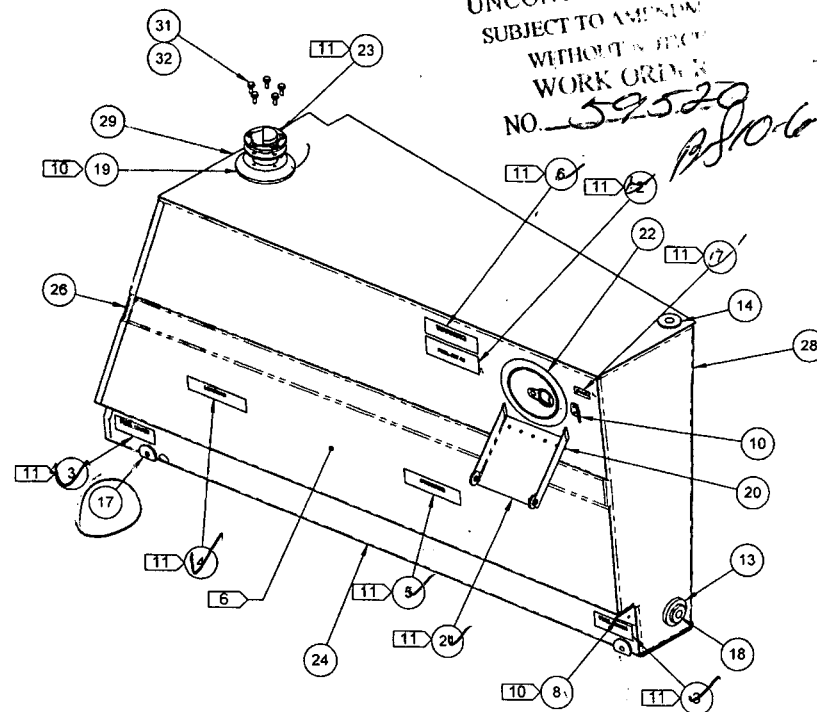
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D4055-041	FUEL TANK ASSEMBLY
2	1	D3999-1	PLACARD "FUEL JET A1"
3	2	D3997-5	PLACARD "AUX FUEL DRAIN"
4	1	D3997-11	PLACARD "LOADING"
5	1	D3997-17	PLACARD "STOWAGE"
6	1	D3997-29	PLACARD "WARNING"
7	1	D3997-43	PLACARD "EARTH"
8	1	D3999-7	CORNER
9	1	D3999-9	ANGLE
10	1	D3999-11	EARTH TAB
11	1	D3999-041	BAFFLE ASSEMBLY, AFT
12	1	D3999-043	BAFFLE ASSEMBLY, FWD
13	1	D4000-1	FUEL SUPPLY FITTING
14	1	D4000-5	FUEL TANK VENT FITTING
15	3	D4000-9	GROMMET
16	1	D4000-043	AFT FUEL SUMP DRAIN ASSEMBLY
17	1	D4000-045	FORWARD FUEL SUMP DRAIN ASSEMBLY
18	1	D4000-047	FUEL PICK UP AND STRAINER ASSEMBLY
19	1	D4001-1	FITTING
20	1	D4008-11	TANK HINGE HALF
21	1	D4008-041	FUEL FILLER SPLASH GUARD ASSEMBLY
22	1	D4023-1	FUEL CAP
23	1	D4025-1	FUEL SENDER
24	1	D4055-11	TANK FRONT AND BOTTOM
25	1	D4055-9	TANK BACK
26	1	D4055-7	TANK FORWARD END
27	1	D4055-5	TANK UPPER CUT OUT
28	1	D4055-3	TANK AFT END
29	1	D4055-1	TANK TOP
30	3	D4057-1	RETAINING RING
31	5	AN3H5A	BOLT
32	5	NAS1149D0363J	WASHER



D4055-041 AUX TANK

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D350-794-041" USING D2729-1 RED DECAL
- 7) WEIGHT: 27.57 lbs
- 8) WELD PER DART QSI 004
- 9) CAP ALL TANK ACCESS POINTS AND PRESSURIZE TANK TO 1.5 PSI AFTER ASSEMBLY. VERIFY NO LEAKS.
- 10) MASK PRIOR TO POWDER COAT
- 11) INSTALL AFTER POWDER COAT

RELEASED
2010-05-05

A	NEW ISSUE	10.04.16
REV.	DESCRIPTION	BY DATE
DESIGN		
DRAWN		
CHECKED		
MFG. APPR.		
APPROVED		
DE APPR.		
DATE	10.04.16	

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4055	REV. A
TITLE TANK	SHEET 1 OF 15
SCALE NTS	
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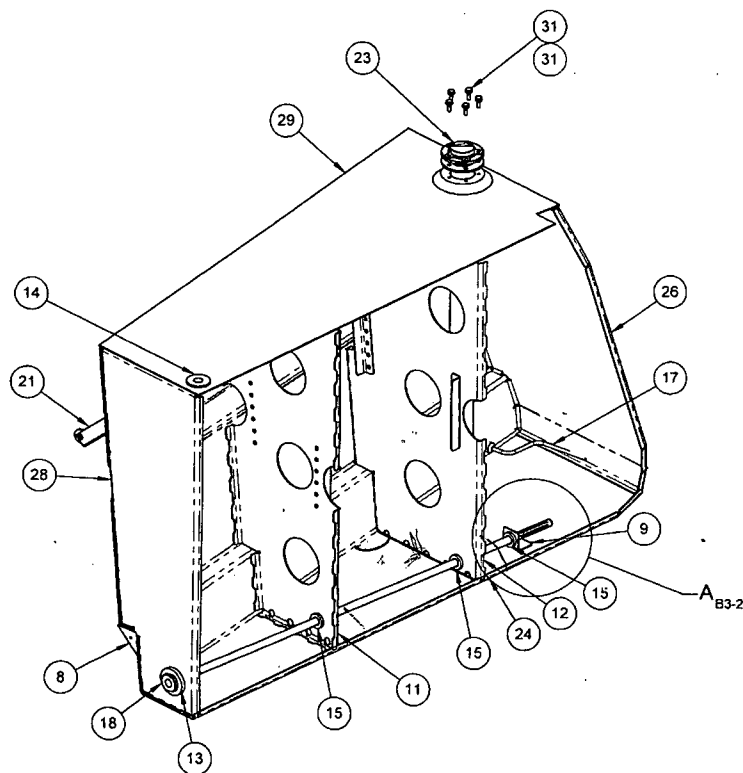
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

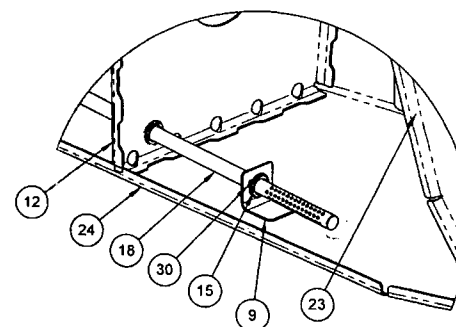
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4055-041 AUX TANK
D4055-9 TANK BACK REMOVED
TO SHOW INTERIOR DETAIL



DETAIL A B3-2
ROTATED FOR CLARITY
SCALE: 2X

w/059520

RELEASED
2010-05-06
MM

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NOTE: Date & initial all entries

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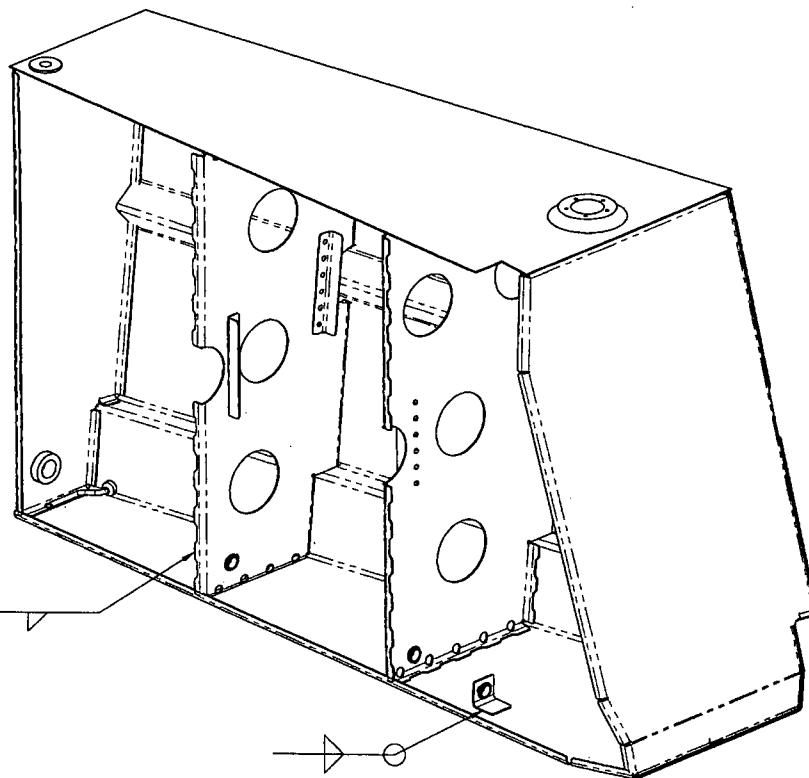
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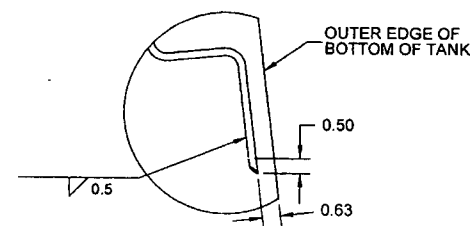
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

WELD ALL TABS



D4055-041 AUX TANK
WELDING DETAIL



DRAIN TUBE INSTALLATION - TYP
VIEWED FROM ABOVE
FWD END SHOWN, AFT END OPPOSITE

4059520

RELEASED
2010-05-05
MP

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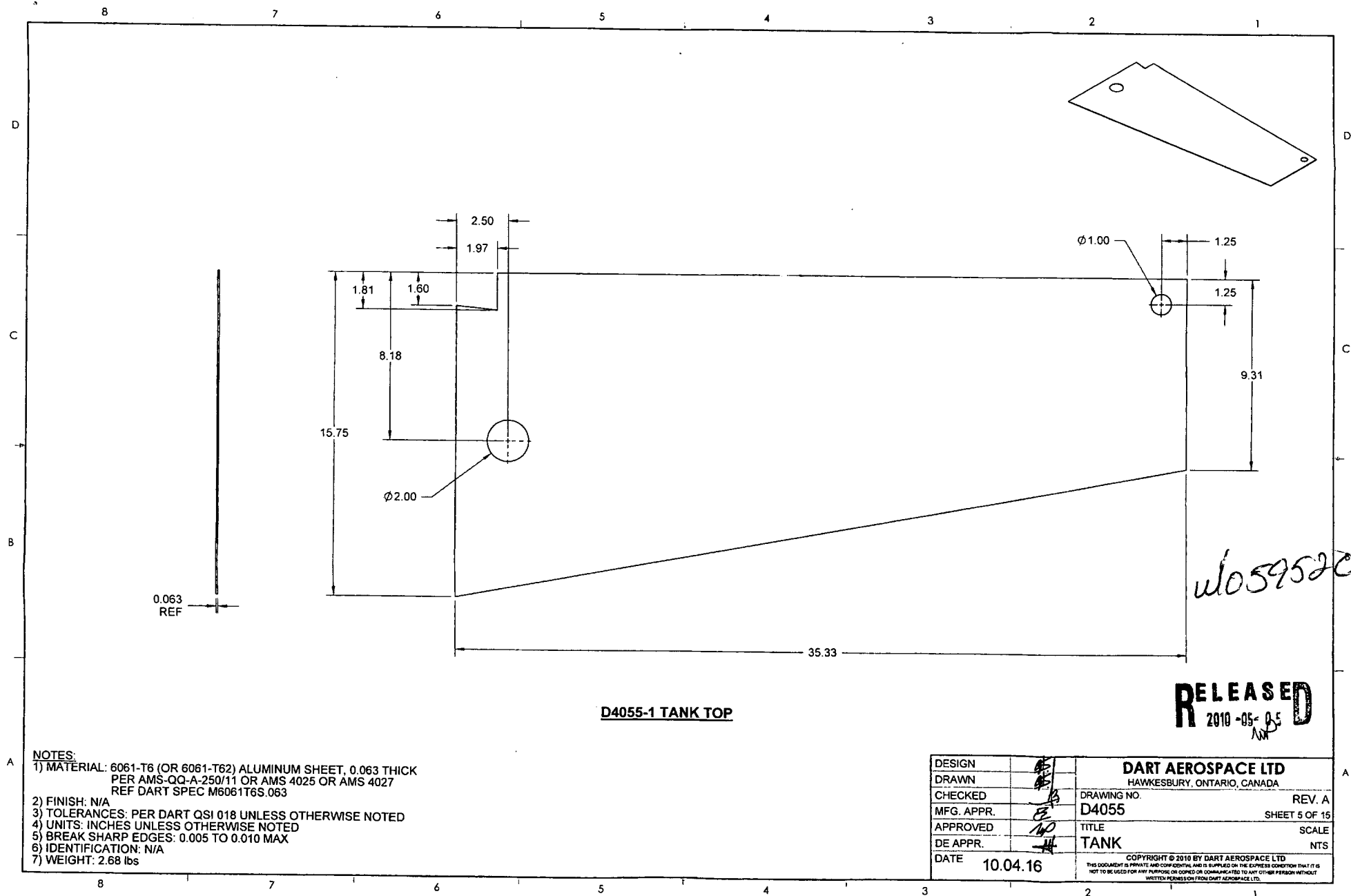
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASE
2010-05-05

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.	REV. A
D4055	SHEET 5 OF 15
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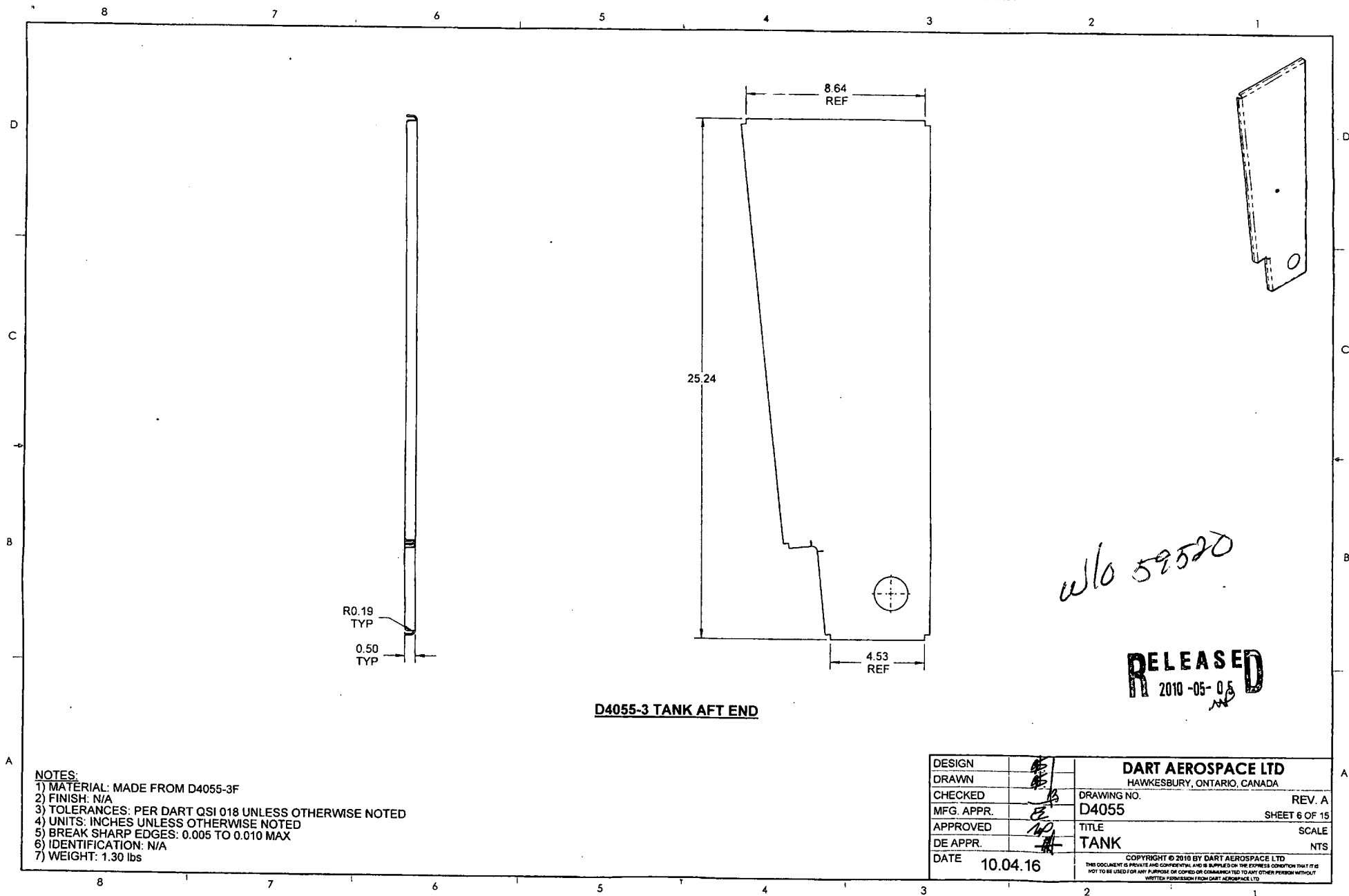
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries



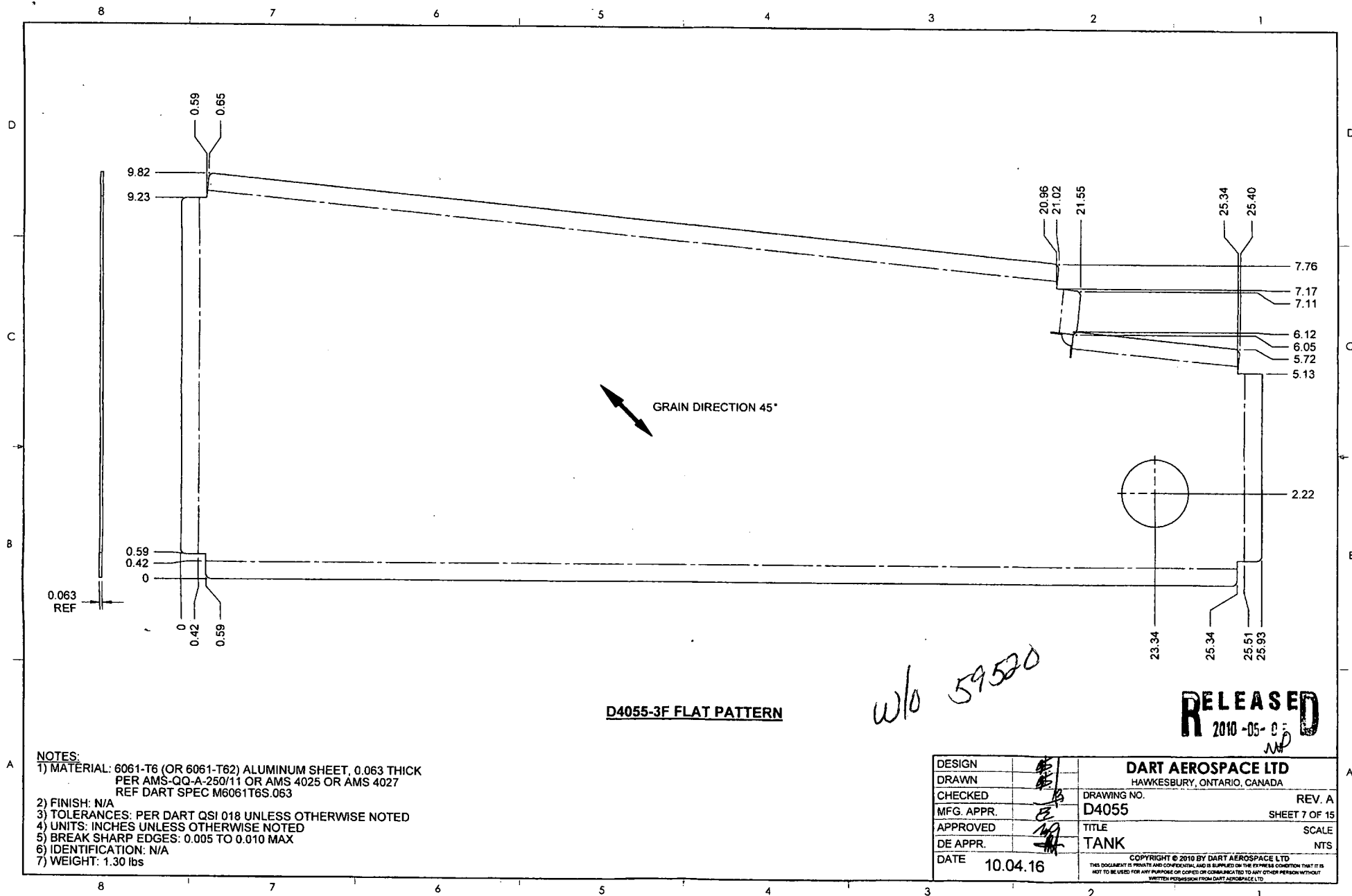
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.063 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.30 lbs

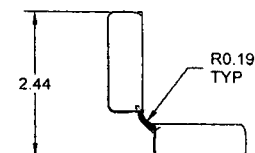
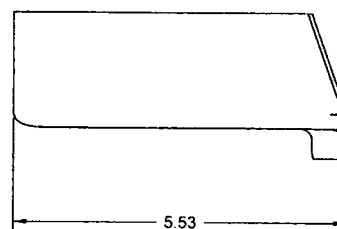
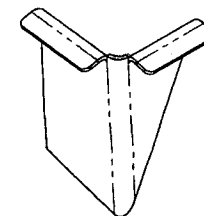
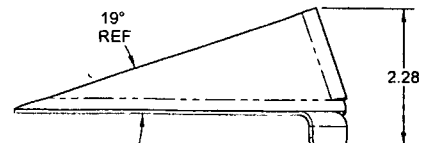
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



W/059520

RELEASED
2010-05-05
WP

D4055-5 UPPER CUT OUT

NOTES:

- 1) MATERIAL: MADE FROM D4055-5F
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.10 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4055	SHEET 8 OF 15
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Dart Aerospace Ltd

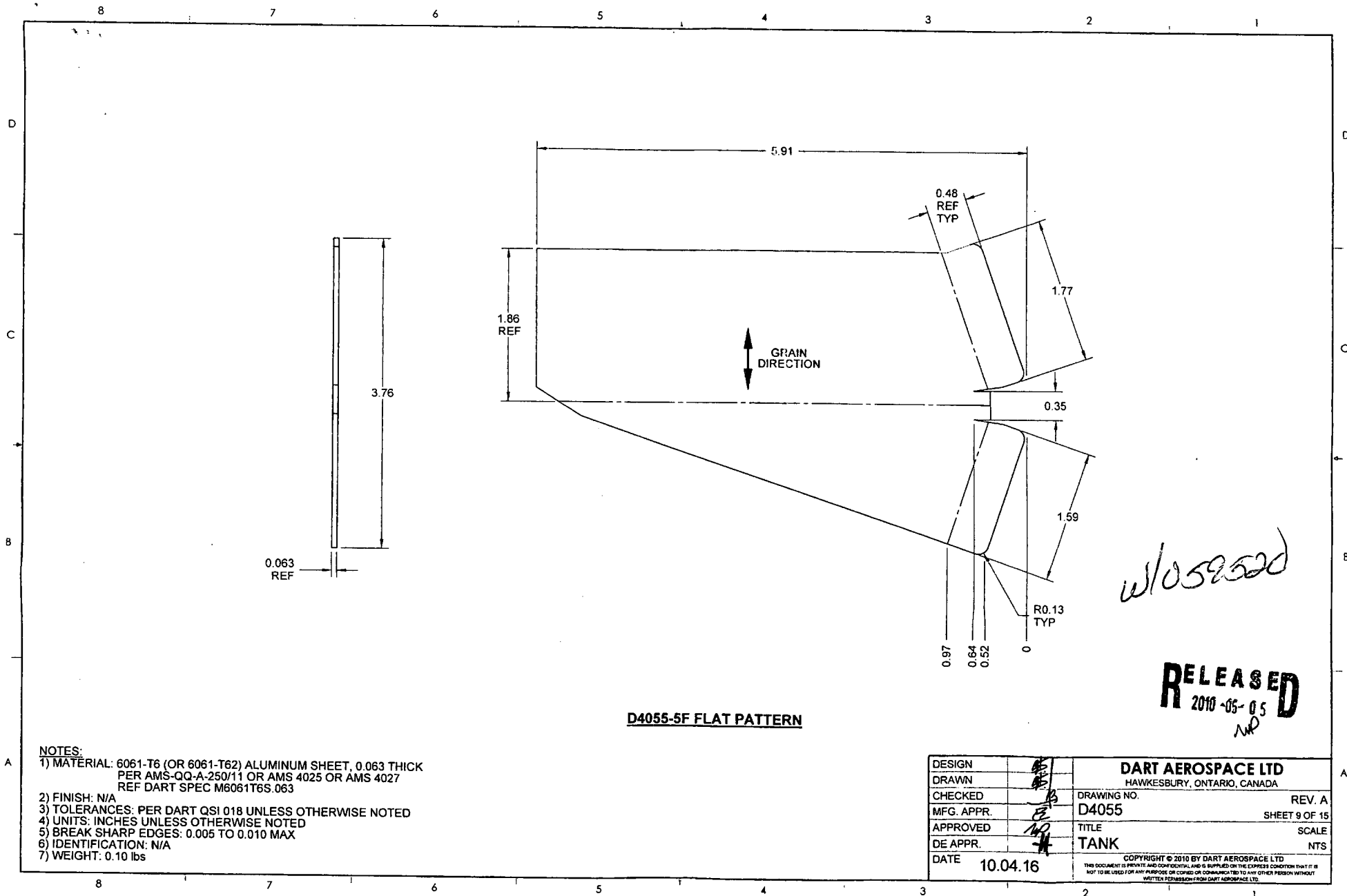
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



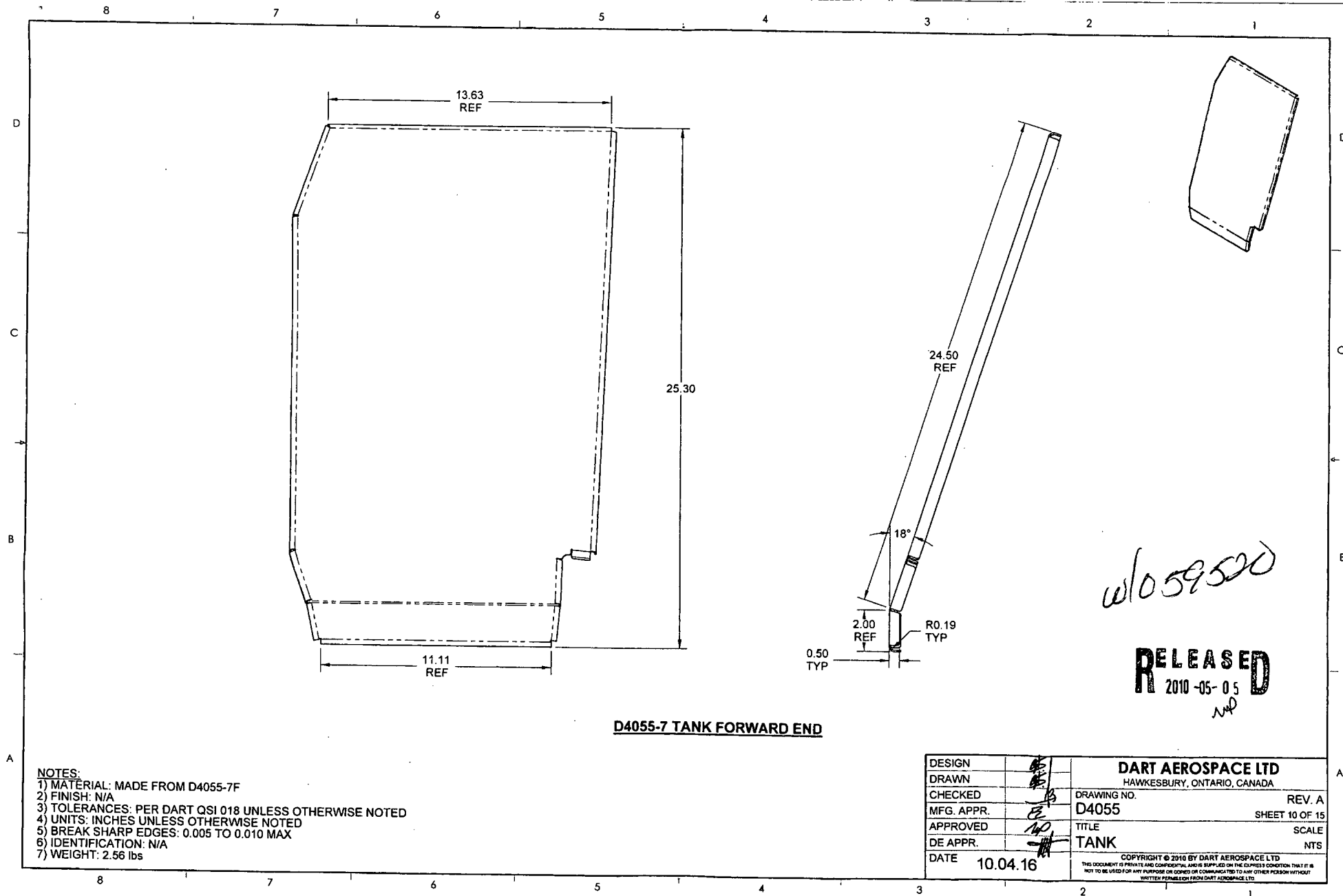
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



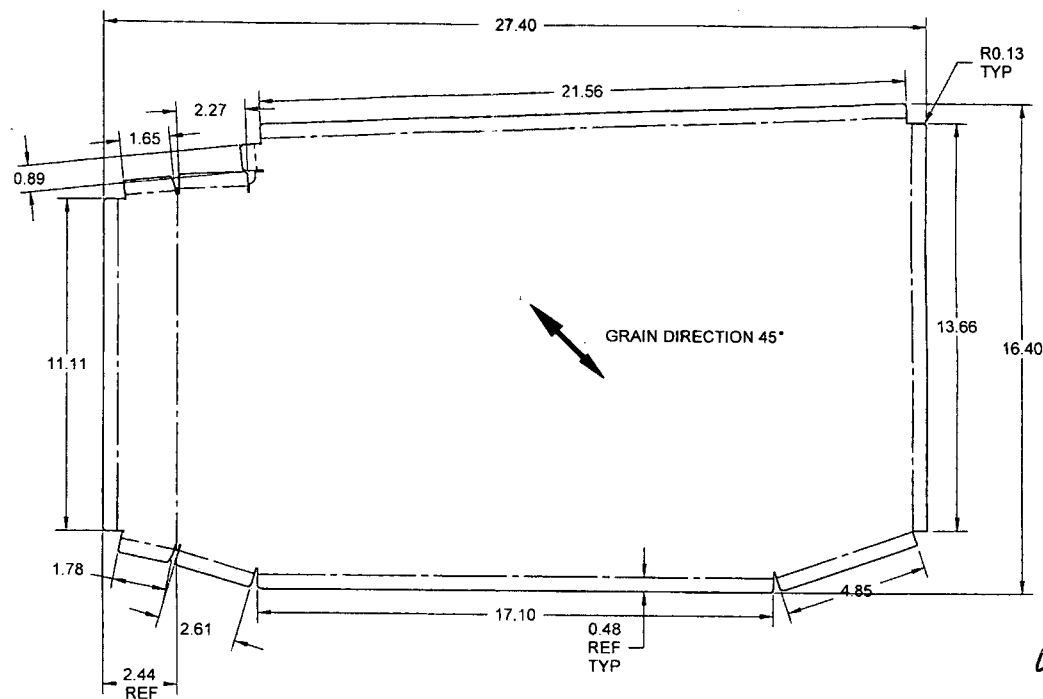
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4055-7F FLAT PATTERN

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.063 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.56 lbs

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MFG. APPR.		D4055	SHEET 11 OF 15
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2010-05-05
NM

W1059520

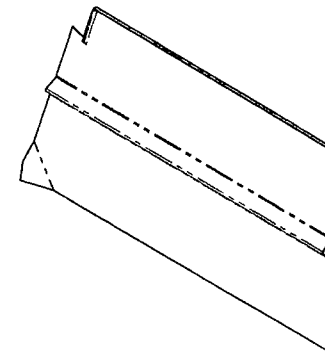
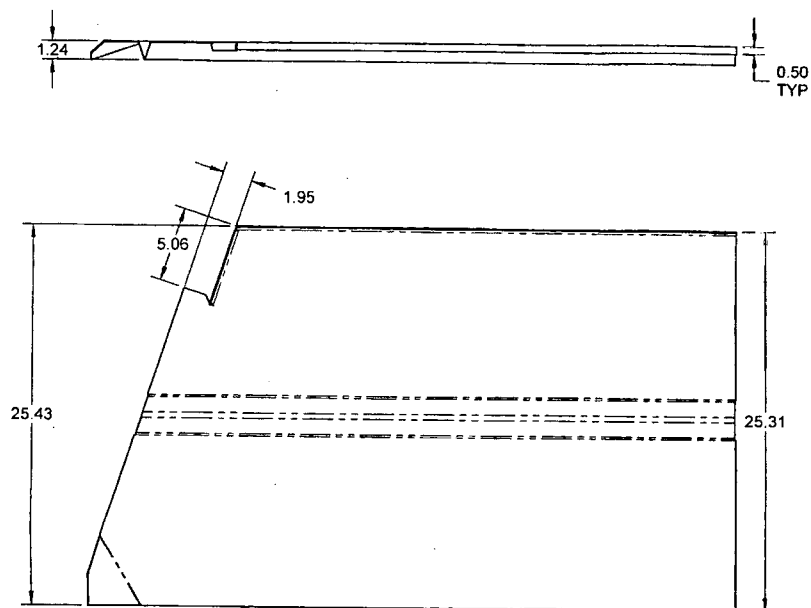
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4055-9 TANK BACK

w/o 59520

RELEASED
2010-05-05
NM

- NOTES:**
- 1) MATERIAL: MADE FROM D4055-9F
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 6.41 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4055	REV. A
MFG. APPR.			SHEET 12 OF 15
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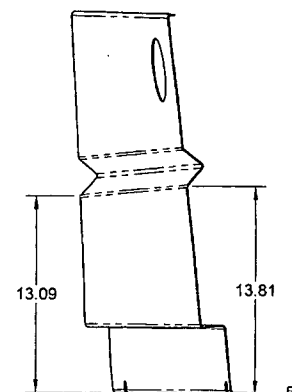
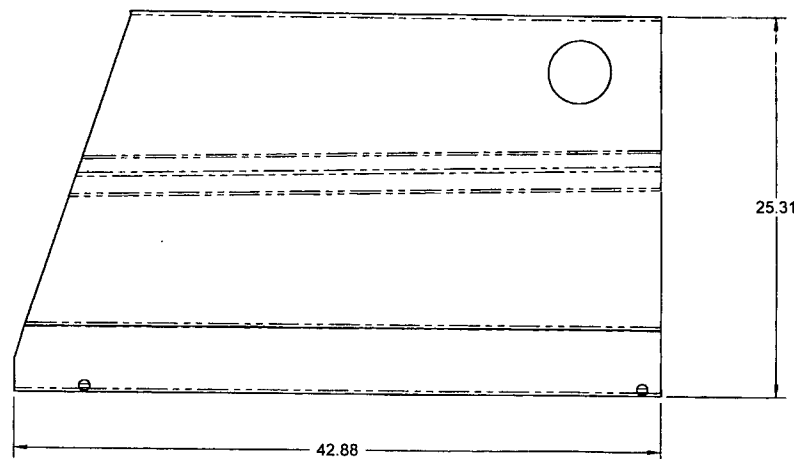
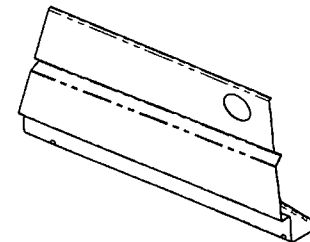
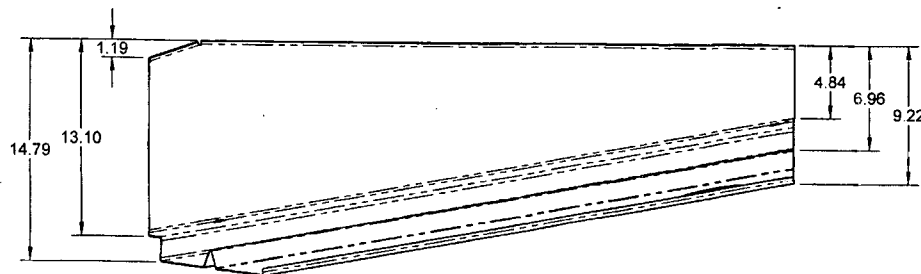
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



w/05952d

RELEASED
2010-05-05
MP

D4055-11 TANK FRONT AND BOTTOM

- NOTES:
 1) MATERIAL: MADE FROM D4055-11F
 2) FINISH: N/A
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: 9.29 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4055	SHEET 14 OF 15
APPROVED		TITLE	SCALE
DE APPR.		TANK	NTS
DATE	10.04.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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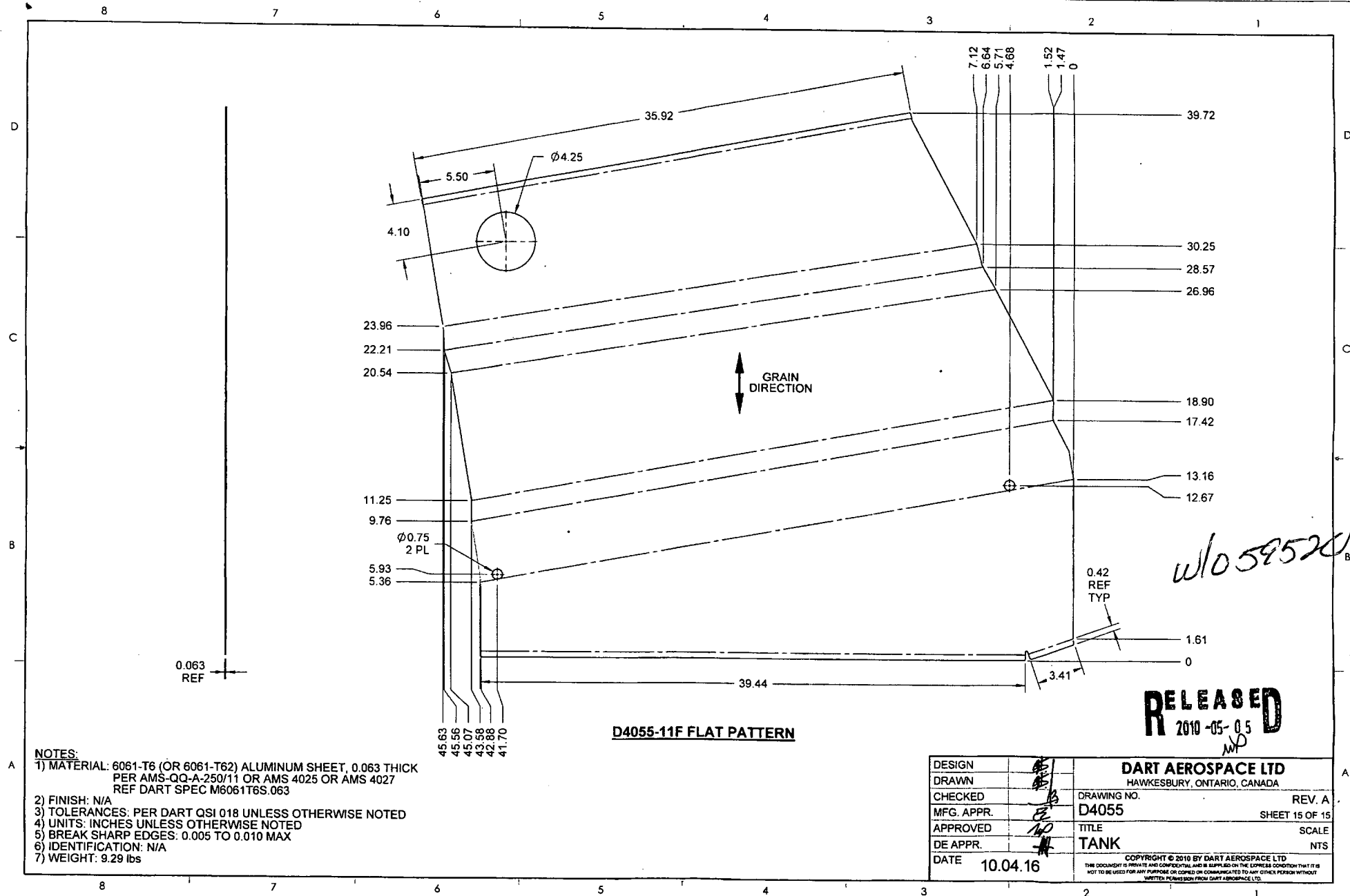
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____







NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4055-11F FLAT PATTERN

RELEASED
2010-05-05

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4055	SHEET 15 OF 15
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries